Sunday, 12/4/2005 12:45:08 PM

Linda Lacelle

Process Sheet

Customer ,

: CU-DAR001 Dart Helicopters Services

Job Number

: 25089B

Estimate Number

: 10353

P.O. Number

This Issue

414:

: 12/4/2005

S.O. No. : N/A

Prsht Rev. First Issue

Previous Run

: NC : NIA

: 24533B

: SMALL /MED FAB

Checked & Approved By Comment

Written By

: Est Rev:A New Issue

05-11-07

Material **Due Date**

Drawing Name

Part Number

: D2278

. D2278 REV D

: STEP LEG

Drawing Number Project Number

: N/A

Drawing Revision

: NA : 12/12/2005

Qty:

40 Um:

Each

Additional Product

Job Number:



Seq.#:

Machine Or Operation:

Description:

5052-H32 .080 Sheet

1.0

M5052H32S080



1.0306 sf(s)/Unit Total: 41.2230 sf(s)

Material: 5052-H32 sheet (QQ-A-250/8) 0.080" Thick

(M5052H32S.080) Identify as D2278 Batch: M 19052

SHEAR



Comment: SHEAR

Comment: Qty.:

Cut blanks: (16.61" x 8.51") +.000/-0.020" (grain along 8.51") for each leg

3.0



HAAS CNC VERTICAL MACHINING #1 J.L



40

- Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2278, use stack of 10

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE 31



05.12.10

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK



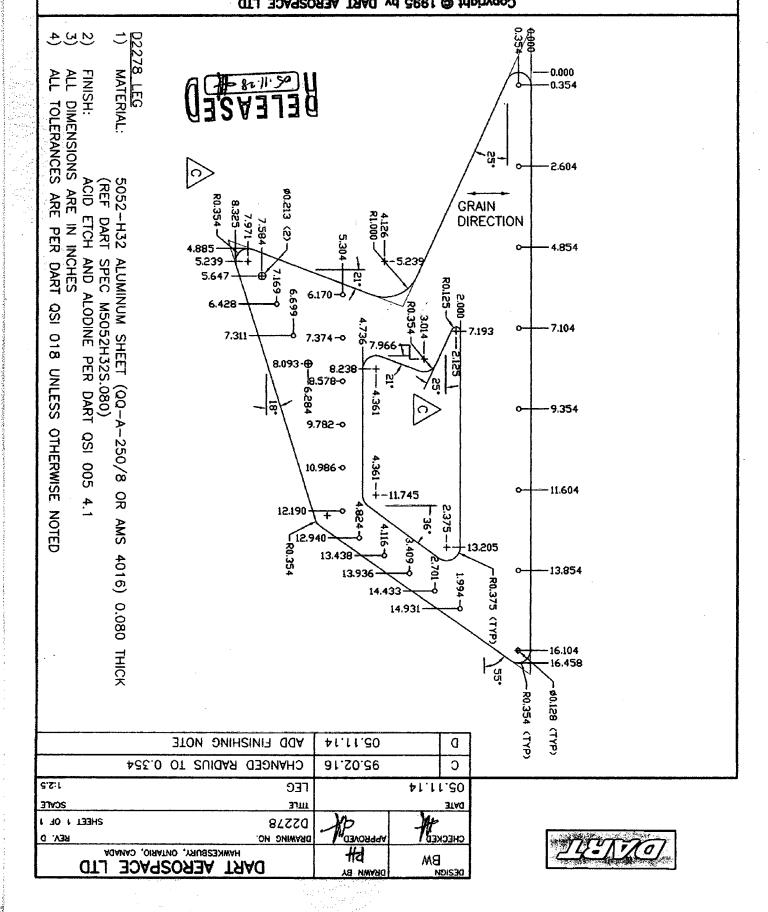
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NOTE: Date & initial all entries

Date: > Sunday, 12/4/2005 12:45:08 PM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: STEP LEG** Job Number: 25089B Part Number: D2278 Job Number: Seq. #: **Machine Or Operation:** Description: 6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr SAD 118/12/05/40 HAND FINISHING1 HAND FINISHING RESOURCE #1 7.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: GA 40 DOCUMENT CONTROL 10.0 DC Comment: DOCUMENT CONTROL 40 Inspection Level 21 Job Completion

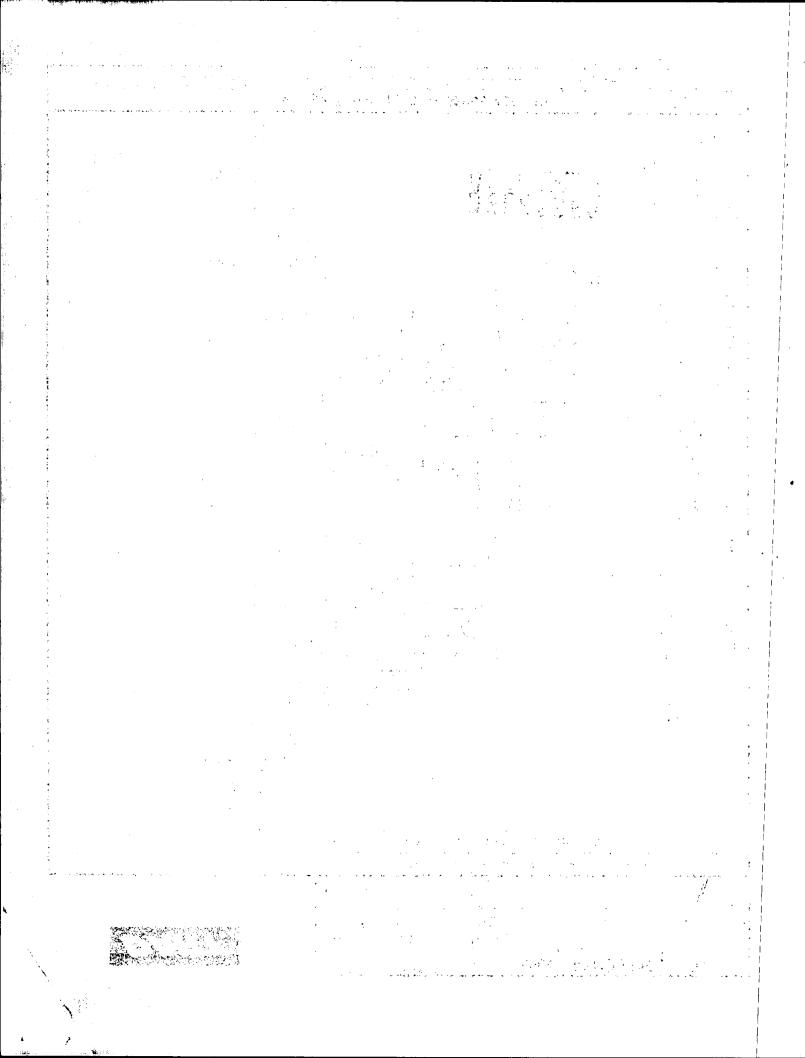
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DART AEROSPACE LTD	Work Order:	
Description: Leg	Part Number:	D2278
Inspection Dwg: D2278 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.354	+/-0.010	353				
0.354	+/-0.010	.353	./			
2.250	+/-0.005	2,250	9			
16.458	+/-0.010	16.455				
Ø0.128	+0.005/-0.000	./31	<i>J</i> ,			
R0.354	+/-0.010	.354				
2.000	+/-0.010	2.001				
4.736	+/-0.010	4.738	1			
8.325	+/-0.010	8.326	1			
Ø0.213	+0.005/-0.000	.214	1			
0.080 thick	+/-0.010	.078				
		-				
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				-		
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Measured by:	T.L	Audited by:	ne	Prototype Approval:	N/A
Date:	05.12.10	Date:	05/2/10	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	04.10.12	New Issue	P/O D2582	KJ/JLM	

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